

Work Order ID 74315

Page 1

Wednesday, September 28, 2011 11:44:27 A

Item ID: D4427-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Scuff Plate

Start Date: 9/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

M.L. JDate: 9/29/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4427

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 13057

Make as per Dwg D4427

Possible Supplier: G.F.Y.

Material release note is required

11-09-29
[Signature]

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

[Signature]

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

[Signature](40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 241A

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/09

MFC 11-11-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 11:44:24 AM

Page 1

Work Order ID: 74315



Parent Item: D4427-1



Parent Item Name: Scuff Plate



Start Date: 9/28/2011

Required Date: 10/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.09.26 NEW ISUUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4427-1P  Scuff Plate		Purchased	No			110	Each	0.0000	1 	10			

Fuller (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

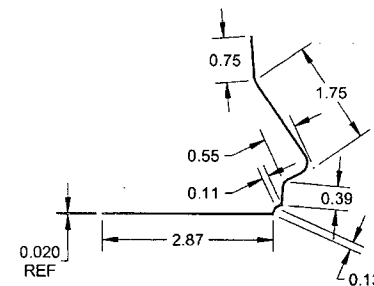
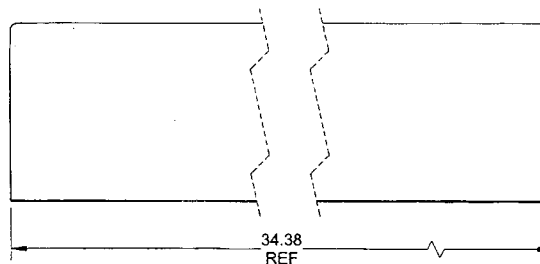
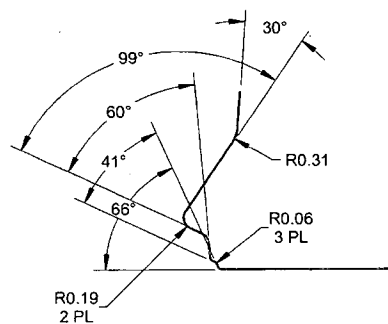
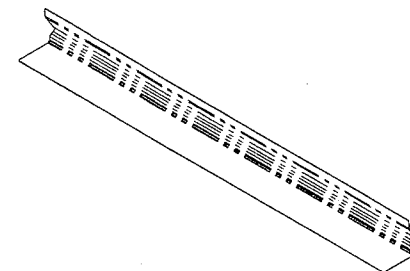
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 74315 M.C. J 9/29/11



D4427-1 SCUFF PLATE

RELEASED
 2011-09-21
 MWD

NOTES:

- 1) MATERIAL: MAKE FROM D4427-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.26 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>SS</i>	D4427	SHEET 1 OF 2
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	SCUFF PLATE	NTS
DATE	11.07.27	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

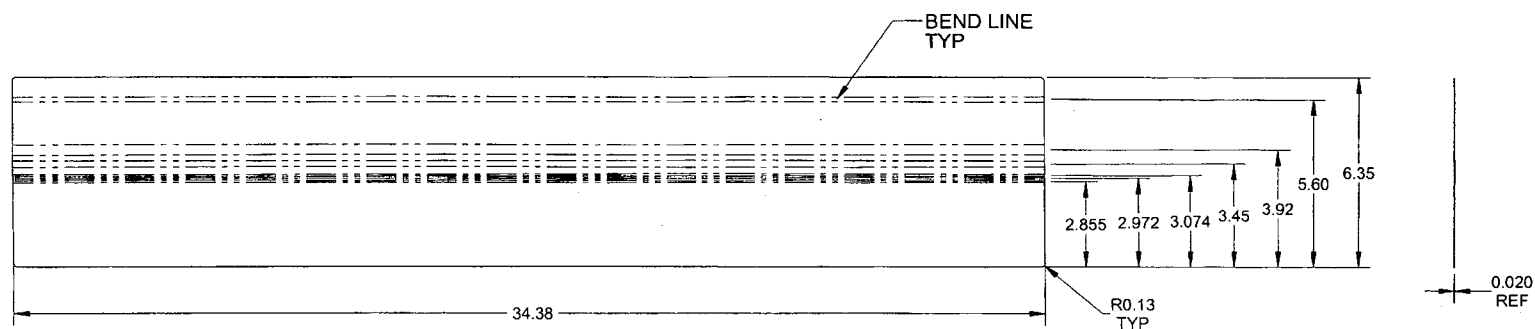
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74315



D4427-1F FLAT PATTERN

RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.020 (25 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.26 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4427	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SCUFF PLATE	NTS
DATE	11.07.27	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID **PO15057**

Purchase Order Date 9/29/2011

PO Print Date 9/29/2011

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4427-1P	Scuff Plate	10/24/2011 Yes	10.00 Each	FedEx PI collect	\$71.0000	\$710.00
		Special Inst:	As per DWG: D4427 Rev:A B74315				
PO Total:							\$710.00

Change Nbr: 3

Change Date: 9/29/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		PAGE
JR - DY	MO - MO	AN - YR			
25	10	11	0472495		1/1

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7



CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART		GFI-0299	0237463	PO15057

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION
---------------------	-----------------------	-------------

10 D4427-1P

SCUFF PLATE

CERTIFICATE OF CONFORMANCE REQ

MFG. JOB# J0237463-001 QTY 10 pcs.



OK

EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES



CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

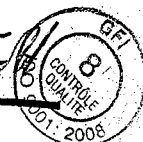
CERTIFICATE NO. <u>1</u>		OUR JOB NO. <u>J0237463</u>		SHIPPING MEMO <u>0472495</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>--</u>	<u>10 PCS</u>	<u>PO15057</u>	<u>D4427-1P</u>		<u>SCUFF PLATE</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>.020 THK 304 A AMS 5513</u>		<u>TW METALS / PENN STAINLESS PRODUCTS</u>		<u>3TE3</u>	
				DWG ISSUE <u>A</u>	

PROCESS	PROCESSOR	RELEASE NOTE #
1 <u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2 <u>REF. GFI MANUFACTURING JOB NUMBER J0237463-001 (10 PCS)</u>		
3 <u>NOTE: PROFILE JIGS INCLUDED WITH SHIPMENTS</u>		
4		
5		
6		
7		
8		
9		

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 25 OCTOBER 2011

G.F.I. Q.C. REP. *[Signature]*





METALS

PACKING SLIP

ORDER NO.: 03285342 FROM: CINC PAGE 1

CUST NUMBER: 1203148 NET WGT: 48.000 REQ.DATE: 10/06/11 CONFIRMED
SOLD TO: SHIP TO:
GFI INC GFI INC
180 AVE. LABROSSE 180 AVE LABROSSE
POINTE CLAIRE QC PIONTE CLAIR QC
CANADA CN H9R 1A1 CANADA CN H9R 1A1

SALESPERSON: DEANNA PIMM DISTRICT: CINCINNATI
TERMS: 1% 10 NET 30 VIA: ROADWAY EXPRES
F.O.B.: SHIPPING POINT FREIGHT: COLLECT
CUST ORD NO.: 0079309 RELEASE NO.:
RECEIVING PHONE: 514 630-4877
WIDTH LENGTH

LINE ITEM DESCRIPTION

0001 08650 304-2B S/S SHEET .018

QTY: 2.000 EA WT: 48.000 PC: 2 SHP: 96 2.000 EA

PART#: TS02048X964A

** 1 TEST REPORTS REQUIRED **

** 1 CERTS REQUIRED **

ECCN: EAR99

Export License: NLR

Expiration Date: 0/00/00

PO:49197333 HT:3TE3

PC: 2

SLB/CL:COIL#013TE3B

MLT:UNITED STATES MFG:UNITED STATES


SHIP VIA EMERY DEFERED ACCT# 543483804 OR YELLOW COLLECT
CLEAR CUSTOMS THRU CONSIGNEE'S BROKER: DHL GLOBAL FORWARDING



PACKING SLIP

ORDER NO.: 03285342 FROM: CINC PAGE 2

CUST NUMBER: 1203148 NET WGT: 48.000 REQ.DATE: 10/06/11 CONFIRMED
SOLD TO: SHIP TO:
GFI INC GFI INC
180 AVE. LABROSSE 180 AVE LABROSSE
POINTE CLAIRE QC PIONTE CLAIR QC
CANADA CN H9R 1A1 CANADA CN H9R 1A1

SALESPERSON:  DEANNA PIMM DISTRICT: CINCINNATI
TERMS: 1% 10 NET 30 7640 REINHOLD DR
F.O.B.: SHIPPING POINT CINCINNATI OH 45237
CUST ORD NO.: 0079309
VIA: ROADWAY EXPRES
FREIGHT: COLLECT
RELEASE NO.:
RECEIVING PHONE: 514 630-4877

"TW Metals MSDS data is available on our web site at www.twmetals.com. MSDS data can be found under the Technical Resources Tab, Product Statistics & Data and the TW Metals MSDS's heading. If you do not have web site access you may telephone 610-458-1300 and we will mail or fax a copy of our current MSDS data to your location."

"CERTIFICATE OF CONFORMANCE"

"TW Metals certifies that the material supplied on this purchase order and contained in the heat/lot number referenced above has been manufactured, inspected, and tested in accordance with the material specification. These records are on file at TW Metals. Packaging material for shipments to Europe and China consists of manufactured wood products and complies with the European emergency measures for coniferous non-manufactured wood packing material"

Electronically Generated Certificate-Valid without signature Date: 10/03/11

These commodities have been exported from the United States in accordance with the U.S. export control laws, export administrations regulations. Diversion contrary to U.S. law prohibited.

THANK YOU FOR THIS ORDER

TERMS AND CONDITIONS APPLICABLE TO THE SALE OF THESE PRODUCTS ARE SET FORTH ON THE REVERSE SIDE FOR YOUR CAREFUL REVIEW.



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 391923 01

Mail To:

Customer: 0470 003

PENN STAINLESS PRODUCTS INC.
P.O. BOX 9001
190 KELLY ROAD
QUAKERTOWN, PA 18951-9001

Ship To:

PENN STAINLESS PRODUCTS INC.
C/O MAIN STEEL
1061 LOUBSON ROAD
UNION, NJ 07083

Date: 4/01/2008

Page: 1

Steel: 304

Finish: 2B

Your Order: 133867

NAS Order: AN 0393367 01

Corrosion: ASTM A262/02aE; 180Band-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/07, 480/06b, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
QQS766D-A X MG FRM, AMS5513H X MRK&FIN, MIL5055D, AMD3, X CRWN MEAS

REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.
EN 10204 3.1; QQS763F Cond A; RoHS Compliant
Product mfg. by a quality mgt. sys. in conf. w/ISO 9001:2000
* Melted & Manufactured in the USA
NACE MRO 175/2001
Minimum solution anneal 1900 F., Water Quenched below 800 F

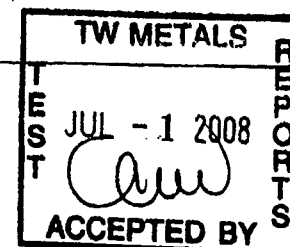
Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
013TE3 B	* 013TE3 B	.0180	48.0000	16,270 COIL	5728.9	11	1

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa)

Heat	CM	C	CO	CR	CU	MM	MO	N	NI	P	S	SI
3TE3	US	.0561	.1322	18.3379	.3882	1.5583	.2876	.0387	8.2546	.0316	.0008	.3878

MECHANICAL PROPERTIES

Product ID #	Coil #	Id	UTS	.20 TS	ELONG	Tail	A 262	Hard
		o i	RTI	RTI	1-2"	Hard	Pr A	R45T
013TE3 B	013TE3 B	F T	100.3	49.64	59.93	50.00	OK	55.00



NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

4/01/2008